

Work Order ID 166086

166086

Page 1

Monday, September 11, 2017 9:18:25 AM

Item ID: D4018-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Rib
 Start Date: 9/11/2017 Start Qty: 36.00 *36* Cust Item ID:
 Required Date: 9/12/2017 Req'd Qty: 36.00 *36* Customer:
 Reference:

Approvals: Process Plan: ^{DAS}21 ⁹⁻⁸⁹ Date: SEP 11 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4018	E								
100		0.00							
100									
Large Fab	Memo	2.16							
Large Fab	1- Cut tube as per dwg D4018 2- debur and remove identification markings								
110	QC6- All purchased or subcontracted products	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: _____	0.00							
120									
Packaging	Memo	0.36							
Packaging	LOCATION: WA004								

36x ~~DC~~ 2017-09-11

DAS
19
9-89
DAS
9
9-89

36 Ø SEP 12 2017

36x D.M.L 2017-9-12

Monday, September 11, 2017 9:18:25 AM

Item ID: D4018-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rib

Start Date: 9/11/2017 **Start Qty:** 36.00

36

Cust Item ID:

Required Date: 9/12/2017 **Req'd Qty:** 36.00

36

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

3.60

Quality Control

DAS
21
9-89

SEP 12 2017

Picklist Print

Monday, September 11, 2017 9:18:29 AM

Page 1

Work Order ID: 166086

166086

Parent Item: D4018-5

D4018-5

Parent Item Name: Rib

Start Date: 9/11/2017

Required Date: 9/12/2017

Start Qty: 36.00

Required Qty: 36.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg
RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD
10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049		Purchased	No			100	f	444.3468	0.5558	21.06189			

✓ *M304TS0 500W 049*

Square Tubing

**

DC 2017-09-11

Location

WA004

Loc Qty

444.34684

4.64684

5.7

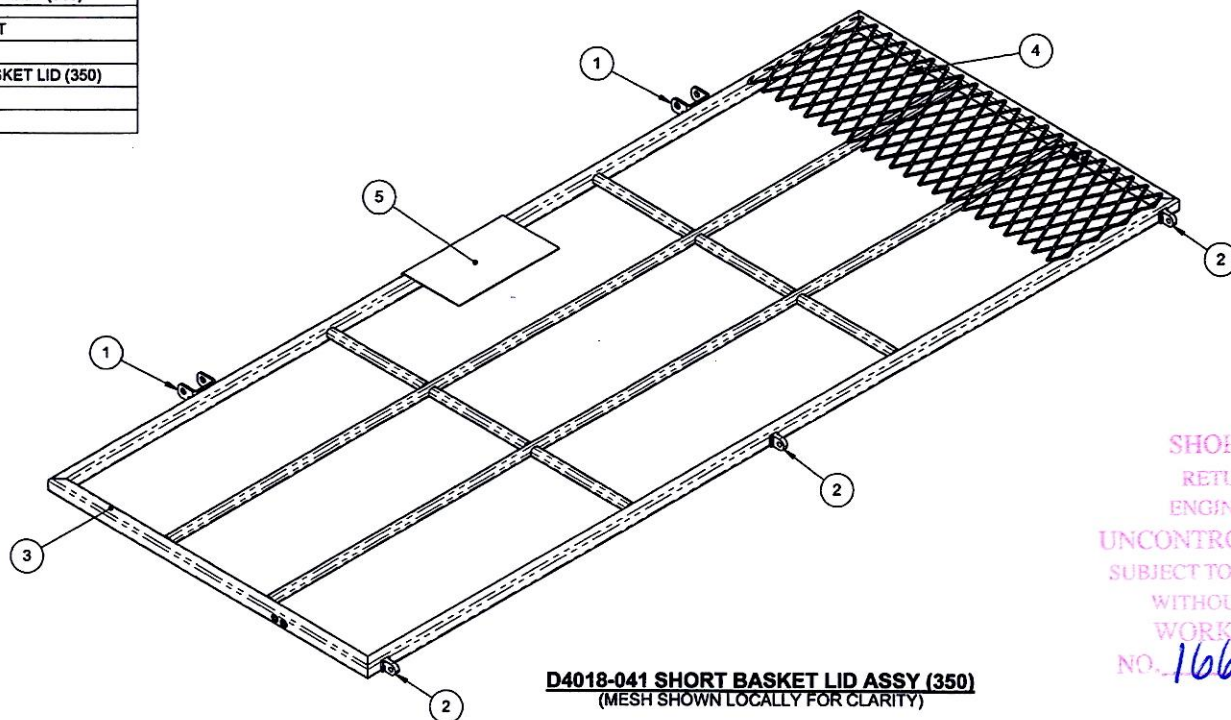
434

Loc Code

B138186 →

22

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	3	D4016-3	HINGE HALF, LID
3	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
4	1	D4020-7	MESH
5	1	D4021-3	DATA PLATE



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166086 MWS
1709-11

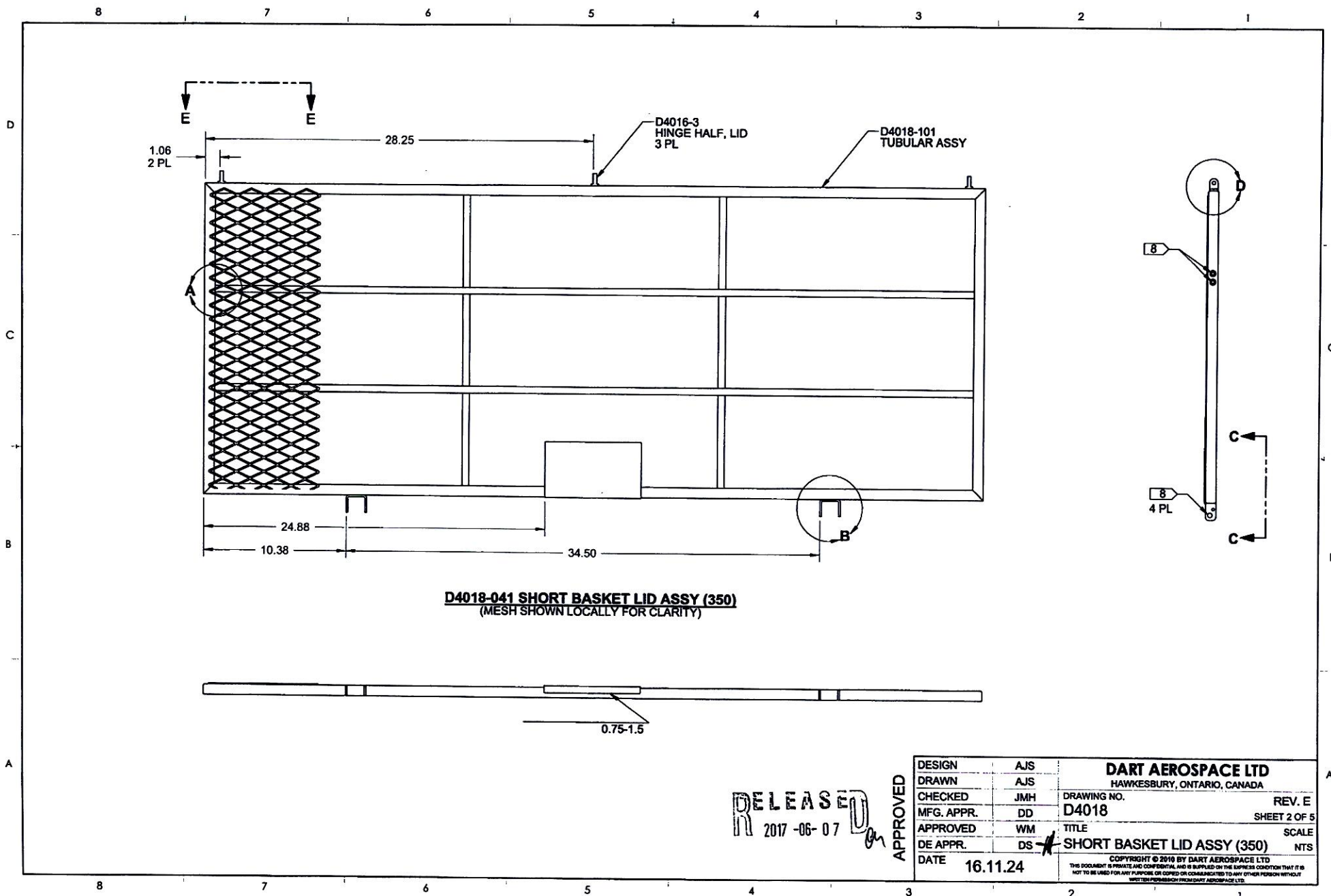
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N AND B/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
- 7) WEIGHT: 14.6 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004
- 10) MASK THIS AREA PRIOR TO FINISH

E	ALL DETAIL/SECTION VIEW LETTERS UPDATED. SHEET 1: D2728-3 DELETED, UPDATED NOTE 6, ADDED NOTES 10. SHEET 2 ADDED VIEW E-E. (PAR15-418)	AJS	16.11.24
D	C7-3 D4035-043 WAS D4035-041 (REASON: PROPARM OPTION DELETED).	AJS	13.07.18
C	REMOVED D4088-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4088-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JMH	DRAWING NO.	REV. E
MFG. APPR.	DD	D4018	SHEET 1 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SHORT BASKET LID ASSY (350)	NTS
DATE	16.11.24	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR QUANTIFIED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2017-06-07
EN 17-580

APPROVED



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2017-06-07

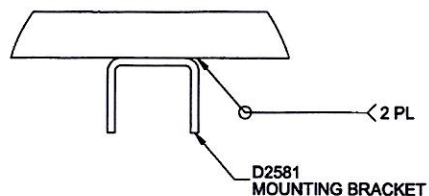
APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. E
MFG. APPR.	DD	D4018	SHEET 2 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SHORT BASKET LID ASSY (350)	NTS
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TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

D4020-7
MESH

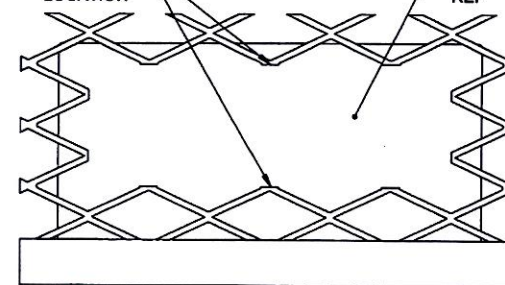
DETAIL A
SCALE 3X



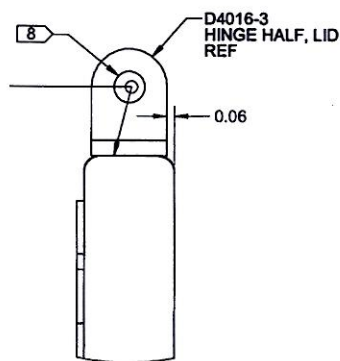
DETAIL B
2 PL
SCALE 3X

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

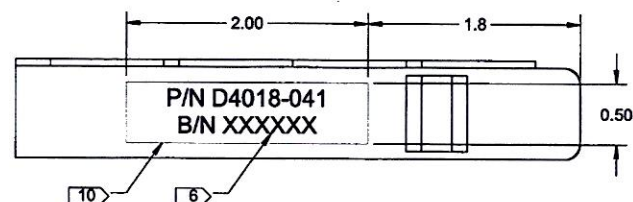
D4021-3
DATA PLATE
REF



VIEW C-C
SCALE 3X



DETAIL D
3 PL
SCALE 3X



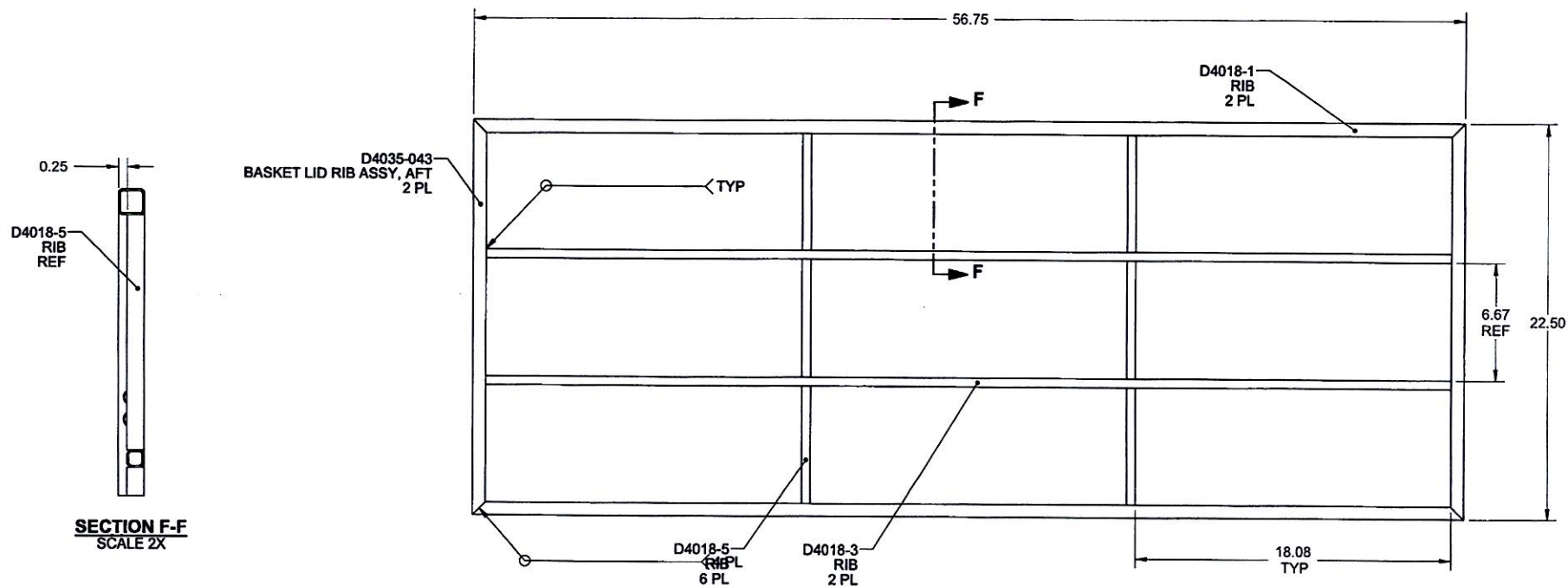
VIEW E-E
SCALE 6X

RELEASED
2017-06-07

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. E
MFG. APPR.	DD	D4018	SHEET 3 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SHORT BASKET LID ASSY (350)	NTS
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	2	D4035-043	BASKET LID RIB ASSY, AFT



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

RELEASED
2017-06-07

APPROVED

DESIGN	AJS
DRAWN	AJS
CHECKED	JMH
MFG. APPR.	DD
APPROVED	WM
DE APPR.	DS
DATE	16.11.24

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4018** REV. E
SHEET 4 OF 5
TITLE **SHORT BASKET LID ASSY (350)** SCALE **NTS**

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